

Date: Wednesday, 9/13/2006 4:30:53 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : EYEBALL ADAPTER
<b>Job Number</b> : 28530	
<b>Estimate Number</b> : 12244	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3480043
<b>This Issue</b> : 9/13/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3480 REV.A <b>UNDER REVIEW</b>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A <b>OK</b> { SEE HAND CHANGE AS PER 06.09.18
<b>Previous Run</b> : 26960	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/6/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : est rev. A 06.02.07 new issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D34801	Flange
-----	--------	--------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-1	Flange	B 28809

2.0	NAS1031C3W	Nutplate
-----	------------	----------



**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
4	NAS1031C3W	Nutplate	M101041

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Spot weld as per dwg D3480

ME - 06/10/03 (4)

4.0	QC5/11	INSPECT WORK/INSPECT SPOT WELD
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**Comment:** INSPECT WORK/INSPECT SPOT WELD

SB 06/10/03 (4)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: ST444

06/10/04 (4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 02/10/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 9/13/2006 4:30:53 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 28530

Part Number: D3480043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



④

Comment: FINAL INSPECTION/W/O RELEASE

SP 06/10/04

Job Completion



C206110104

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

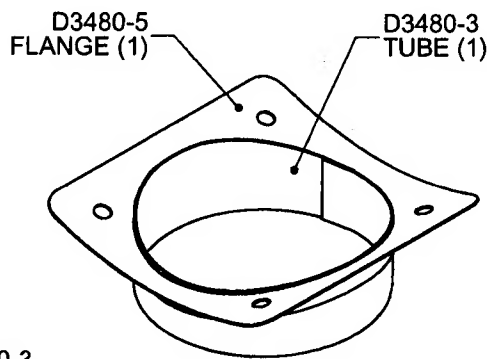
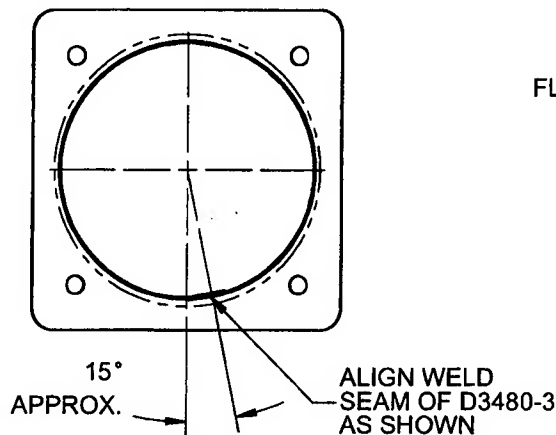
**NOTE:** Date & initial all entries



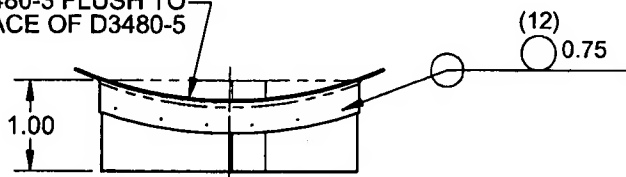
DESIGN #	DRAWN BY #	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3480</b>	REV. A SHEET 1 OF 6
DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2
A	06.02.06	NEW ISSUE	

# 06.04.03

**UNDER REVIEW**  
06.05.17



SPOT WELD PARTS, THEN  
CUT D3480-3 FLUSH TO  
SURFACE OF D3480-5



### D3480-041 EYEBALL INLET ADAPTER

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

#### **NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

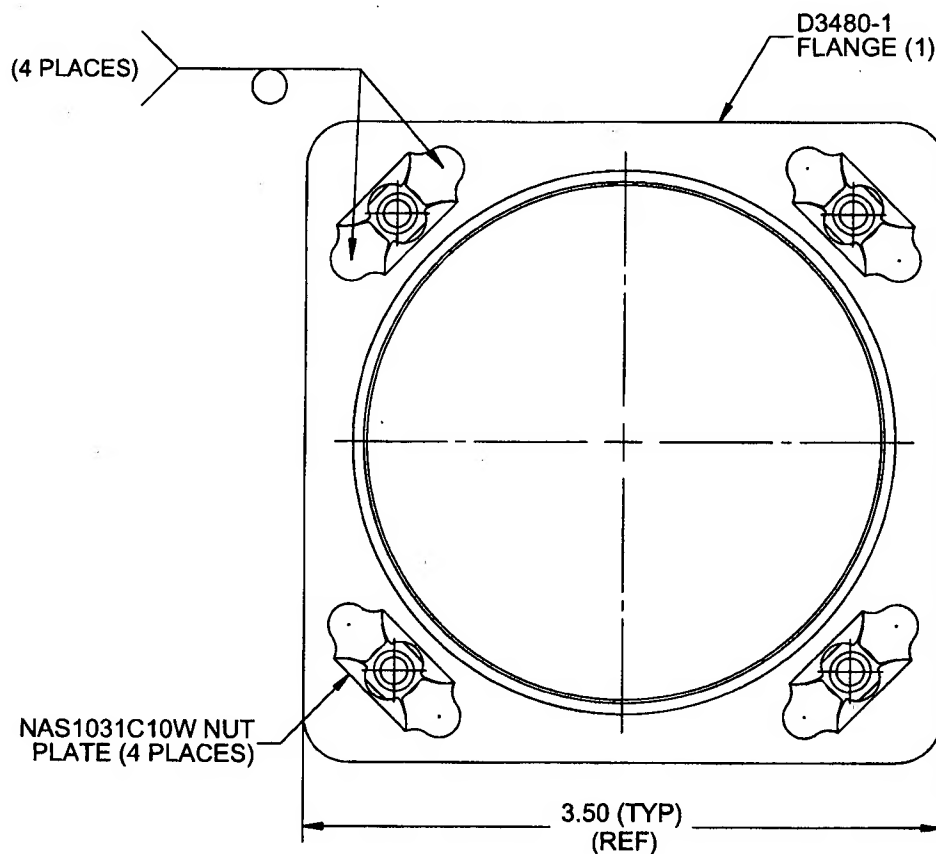
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DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:1

**UNDER REVIEW**  
*[Signature]*  
06.07.12



**D3480-043 EYEBALL ADAPTER**

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WORK ORDER  
NO. \_\_\_\_\_

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

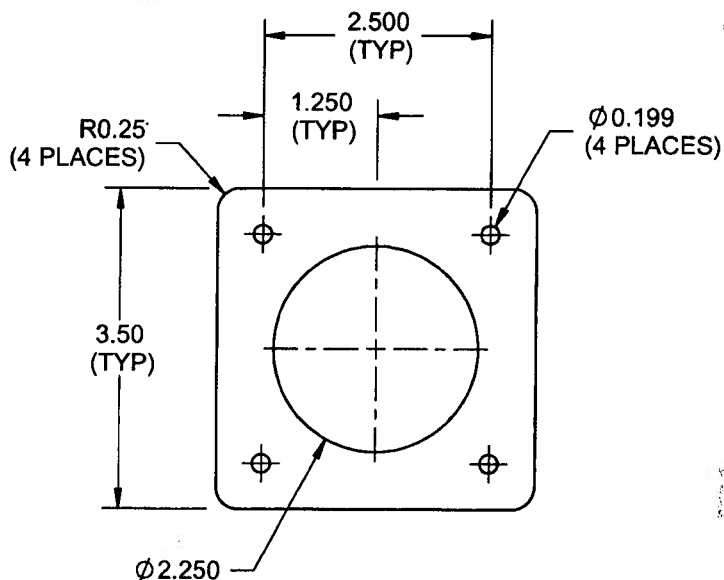
QTY -041	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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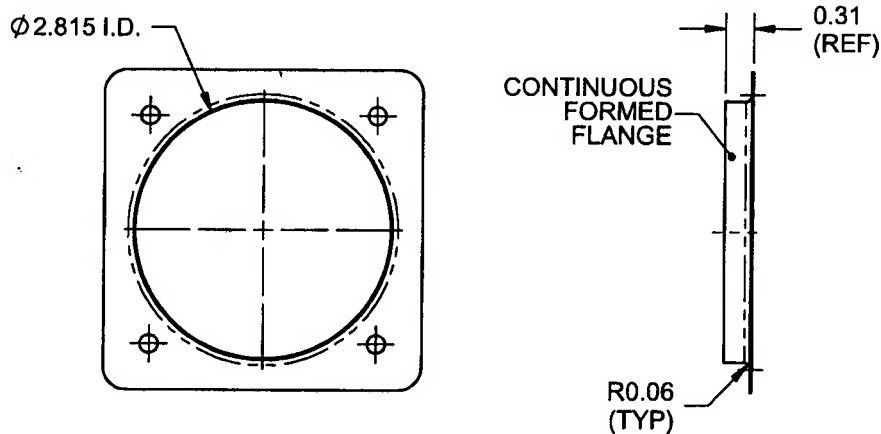
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. A SHEET 3 OF 6
DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



UNDER REVIEW  
06.05.17 *[Signature]*

06.04.03 *[Signature]*

### D3480-1F FLAT PATTERN



### D3480-1 FLANGE (MAKE FROM D3480-1F)

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

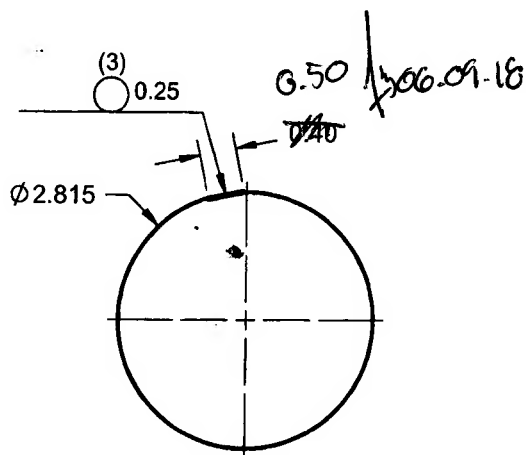
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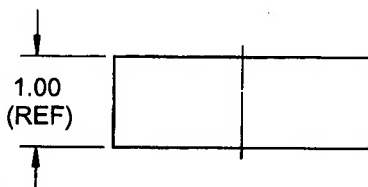
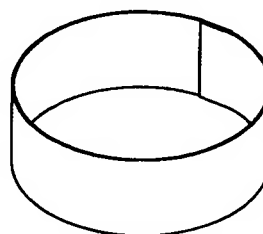
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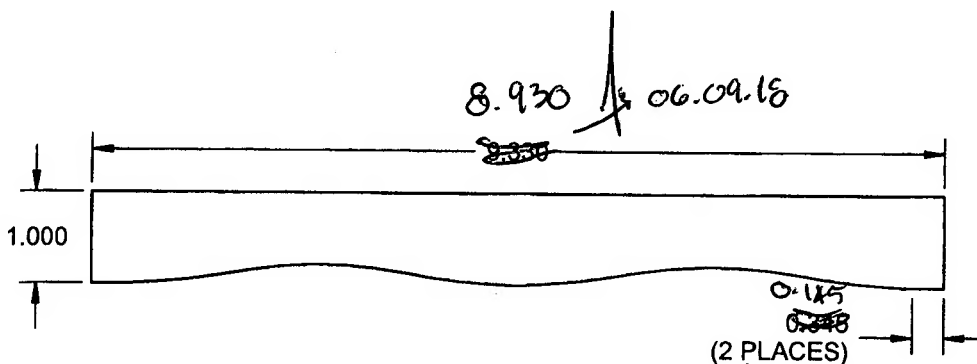
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. A SHEET 4 OF 6
DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



UNDER REVIEW  
06.05.17 *[Signature]*



**D3480-3 TUBE**



**D3480-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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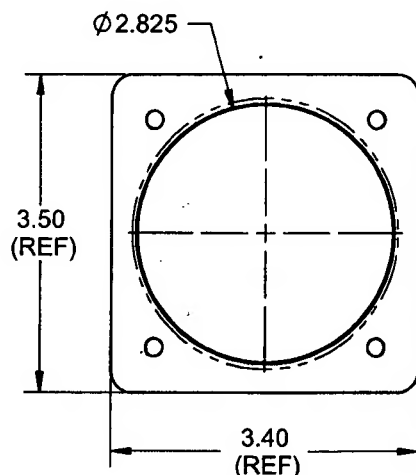
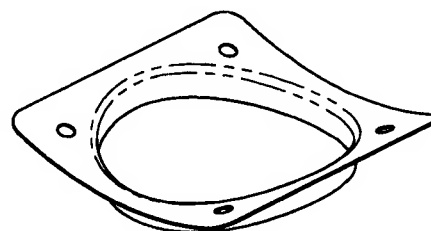
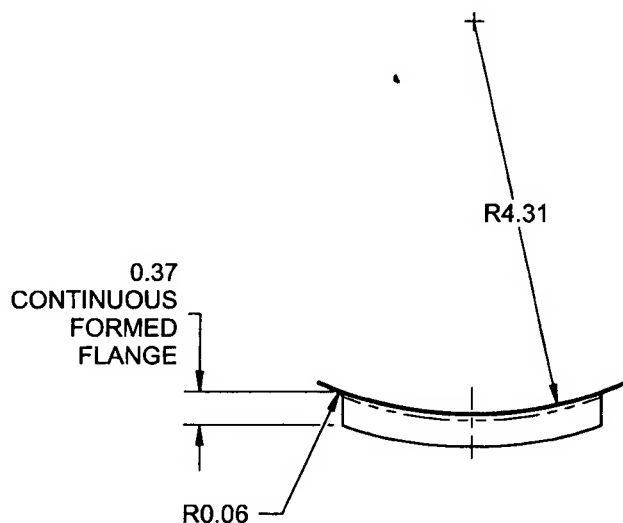
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



UNDER REVIEW  
06.05.17 *[Signature]*

*[Signature]* 06.04.03

### D3480-5 EYEBALL ADAPTER FLANGE

#### NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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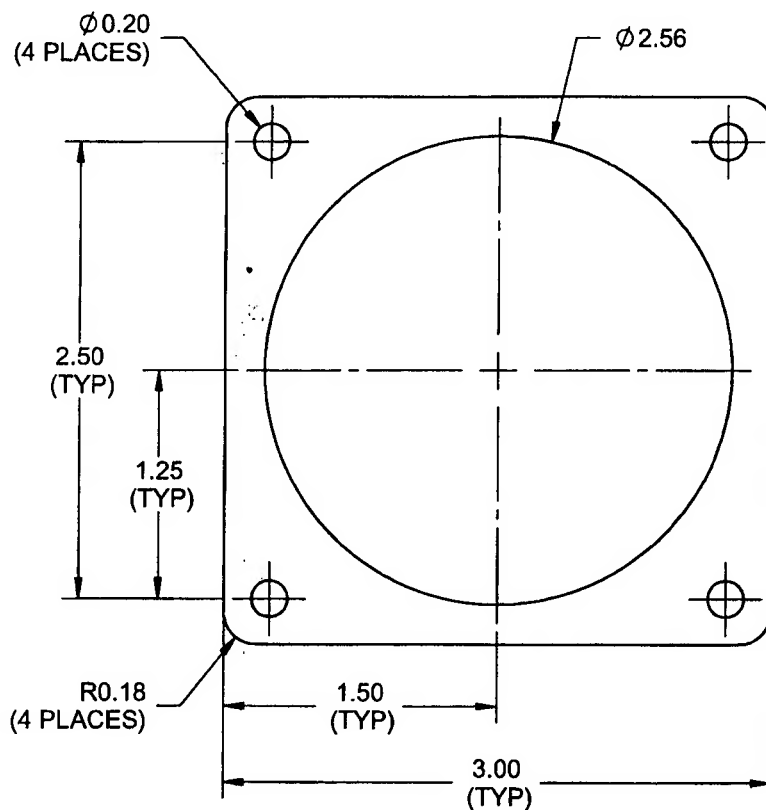
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DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:1

**UNDER REVIEW**  
*[Signature]* 06.03.17



*[Signature]* 06.04.03

### D3480-7 GASKET

#### NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 22

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Melanie Fauter  
Joint Welding Procedure Spot Welding  
Part number and Job number D 3480-043

TEST WELDS REQUIRED

BASE METAL	<u>304 2G</u>		WELDING PROCESS	<u>Spot</u>	
Penetration	Complete <input type="checkbox"/>	Partial <input type="checkbox"/>	Single Weld	<input type="checkbox"/>	Double Weld <input type="checkbox"/>
Current	AC <input type="checkbox"/>	DC <input checked="" type="checkbox"/>	Backing	YES <input type="checkbox"/>	NO <input checked="" type="checkbox"/>
	Position	Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>			
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>	
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>	
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>	N/A
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>	
Crossbolt Spacer	Welded into		Skidtube		

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☐ Fail ☐ N/A

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/03 Qualifier Sylvie Boucher